

Rush

Work Order ID 122388

122388

Page 1

July-15-14 12:40:17 PM

Item ID: D4977-2 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Bracket, RH

Start Date: 7/15/14 Start Qty: 5.00 *5* Cust Item ID:

Required Date: 8/08/14 Req'd Qty: 5.00 *5* Customer:

Reference:

Approvals: Process Plan: V Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4977	C

110

0.00

110

Outsource5

Memo

0.00

Outsource process - Machining

ISSUE P/O: 25010
POSSIBLE SUPPLIER: WEJAY

Certificate of conformaty required

CL 14/07/15 S

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

5x SP 14-8-22

117

QC6- Inspect dimensions to drawing

0.00 DAS

117

QC

Memo

0.00 16
9-89

Quality Control

14/08/2273

-2

Work Order ID 122388

122388

Page 2

July-15-14 12:40:17 PM

Item ID: D4977-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket, RH
 Start Date: 7/15/14 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 8/08/14 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
120									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : <u>25511</u>								
	1- Black Anodize as per Dwg								
	<u>2- PRIME AS PER DWG, SEE NOTE #2</u>								
	Certification of Conformity is required								
	QC 14								
130	Receive & Inspect for Damage & Mat'l Certs	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

CL 14/108/25 S

CL 14-08-27 (5)

DAS
41
9-89
14-8-28 (5)

14/8/27 (5)

S 14-8-27

Work Order ID 122388

122388

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July-15-14 12:40:17 PM

Item ID: D4977-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket, RH
Start Date: 7/15/14 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 8/08/14 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>ST 129</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging	***IDENTIFY BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MF 14-8-28

MLG 1408-28

MF 14-8-28

Picklist Print

July-15-14 12:40:16 PM

Page 1

Work Order ID: 122388

122388

Parent Item: D4977-2

D4977-2

Parent Item Name: Bracket, RH

Start Date: 7/15/14

Required Date: 8/08/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV: A NEW ISSUE JFS 13/11/22 VERIFY BY: JLM IPP
REV:B 14.06.16 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M7075T6B4.000X03.00
0

Purchased

No

f

6.0600

2

M7075T6B4 000X03 000

7075-T6 BAR 4.000" X 3.000"

**

1/4 mat sup by wijay.

Location

Loc Qty

Loc Code

MAT001

6.06

125584

1

M127736

5.06

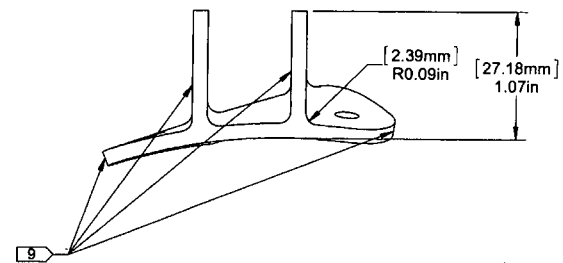
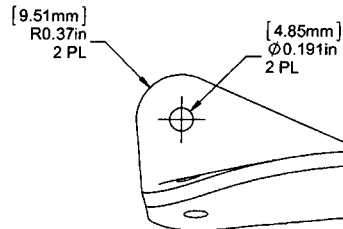
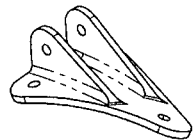
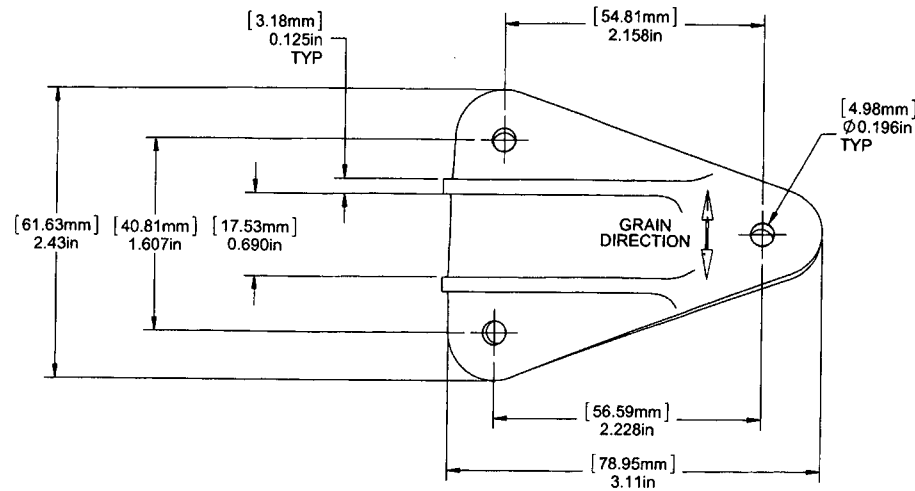
D4977-2 P

15

122388

ME 14-8-28

8 7 6 5 4 3 2 1



D4977-2 BRACKET, RH

W/O 122388

RELEASED
2014-06-11

NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4977-2", REVISION, BATCH NUMBER AND
DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 0.09 lbs (0.04 kgs)
- 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4977-2-c.IGES
- 9) IT IS ACCEPTABLE FOR THESE EDGES TO BE PARALLEL WITH EACH OTHER

APPROVED	DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	HS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D4977	SHEET 2 OF 2
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	BRACKET	NTS
	DATE	14.06.05	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

DART
AEROSPACEDart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053**PURCHASE ORDER**Purchase Order ID **PO25010**

Purchase Order Date 7/15/2014

PO Print Date 7/15/2014

Page Number 2 of 2

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA**Ship To :**DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA**Contact Name****Vendor Phone**

613-384-1662

Ship To Contact**Ship To Phone****Ship Via:**

FedEx PI ppd

Ship Acct:**Buyer**

Chantal Lavoie

Customer POID**Customer Tax #**

10127-2607

Terms

COD

Currency

CAD

FOB

Destination-Collect

3	D4977-2P	Bracket, RH	8/22/2014	FN	5.00	✓	\$425.00	\$2,125.00
			Yes		Each			
			8/22/2014					

AS PER DWG D4977 REV. C
B122388**Line Total:** \$2,125.00

4	71401-45	PROCUREMENT QUALITY CLAUSES	8/22/2014		1.00	✓	\$0.00	\$0.00
			No					
			8/22/2014					

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER,
(DOCUMENTATION SENT TO DART AEROSPACE)

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS
APPLICABLE)

A024 PROCESS CERTIFICATIONS

A025 CERTIFICATE OF CONFORMANCE

A040 NOTIFICATION OF QUALITY ESCAPE

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$0.00**PO Total:** \$9,000.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 7/15/2014



Packing Slip 36927

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1
 TEL: 613-384-1662 FAX: 613-384-29
 www.wejay.ca

SOLD TO Dart Aerospace
 1270 Aberdeen Street
 Hawkesbury ON K6A 1K7

SHIP TO Dart Aerospace
 1270 Aberdeen Street
 Hawkesbury ON K6A 1K

INVOICE DATE		YOUR ORDER NO. PO25010		DATE ORDERED 07/15/14		SHIPPED VIA Best way	
CUSTOMER CODE DART			PROV. LIC. NO.		Extra <input type="checkbox"/> Exempt <input type="checkbox"/>		TERMS
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION			UNIT PRICE	AMOUNT
5	-	5	Windshield deflector, upper as per drawing D4970, Rev. C D4970-3P B122215				
5	-	5	Bracket, left hand as per drawing D4977-1, Rev. C D4977-1P B122387				
5	-	5	Bracket, right hand as per drawing 4977-2, Rev. C D4977-2P B122388				
<p>Required by: August 22, 2014</p> <p>RELEASE NOTE</p> <p>I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.</p> <p>Inspection Supervisor <i>[Signature]</i> WMP 03</p> <p><i>Aug. 21/14</i></p>							
						G.S.T.	-
						P.S.T.	

ORDER: COMPLETE ☐
 PARTIAL ☐

TOTAL

RECEIVED BY _____
 1.5% PER MONTH (18% PER ANNUM)
 CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
 PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2901

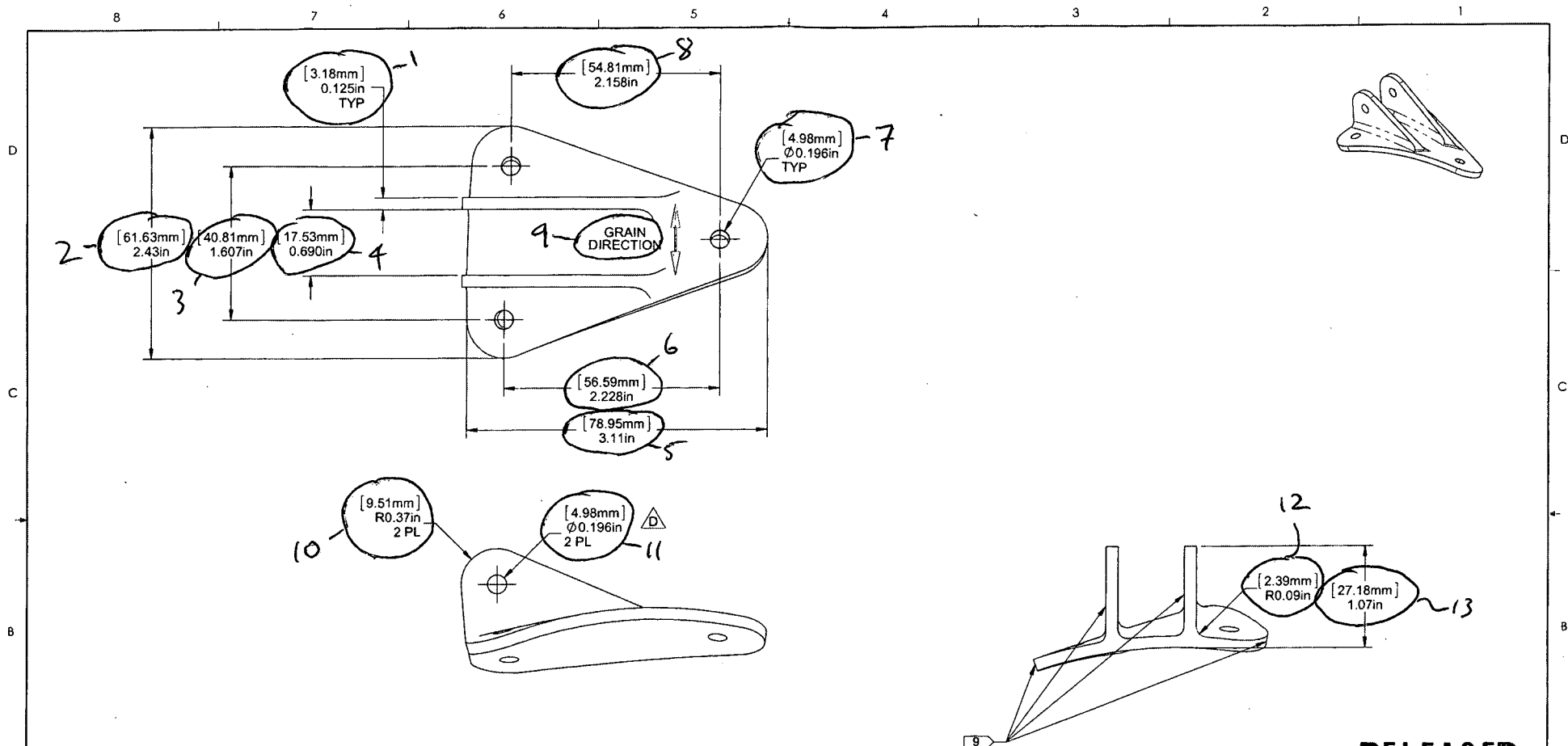
CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace Ltd.		DATE: Aug. 21, 2014	
		P.O.# PO25010	
		WEJAY JOB# 36927	
<p>I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.</p>			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4970-3P 'Upper Windshield Deflector' B122215	5	Machined complete per drawing req'ts.	D4970 / rev. C
D4977-1P 'Bracket, Left Hand' B122387	5	Machined complete per drawing req'ts.	D4977 / rev. C
D4977-2P 'Bracket, Right Hand' B122388	5	Machined complete per drawing req'ts.	D4977 / rev. C
Note: 1) Material is Dart Aerospace free issue. Ref. Dart PO# PO22281. 2) 1st Article Inspection reports attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith
Authorized Q.A. Signatory



D4977-2 BRACKET, RH

NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N: 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4977-2", REVISION, BATCH NUMBER AND
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- 7) WEIGHT: 0.09 lbs (0.04 kgs)
- 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4977-2.d.IGES
- 9) IT IS ACCEPTABLE FOR THESE EDGES TO BE PARALLEL WITH EACH OTHER

APPROVED

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4977	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2014-07-28



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No.

36927

PAGE: 1 of 1

CUSTOMER: DART Aerospace

CUST. P.O.# 25010

PART No. D4977-2

DESCRIPTION: BRACKET, R-H.

DWG No. D4977

REV. D

E.C.O.

MATERIAL: 7075 ASTM B209 DART Supplied

INSPECTOR

IN PROCESS:

FINAL:

DATE:

QUANTITY

ACCEPT:

REJECT:

N.C.R.#

REC'D: 5

5

0

AUG 21/14

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	IN PROCESS INSPECTION	FINAL INSPECTION	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------------------------	---------------------	---------------	---------------------------------------

1	0.125" TYP		+/- .01			.124-.127		
2	2.43"		+/- .03			2.434		
3	1.607"		+/- .01			1.606		
4	.690"		+/- .01			.691		
5	3.11"		+/- .03			3.10		
6	2.228"		+/- .01			2.229		
7	0.196" dia. TYP		+ .005 / - .001			.197		
8	2.158"		+/- .01			2.158		
9	Grain Direction				verified before machining			
10	R0.37" 2 places		± .03			.37 R.		
11	0.196" dia x2		+ .005 / - .001			.197 x2		
12	R.09"		+/- .03			.09 R.		
13	1.07"		+/- .03			1.070		
14								
15								
16								
17								
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A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63226

Date: 27-Aug-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	Line:
5 ea	Part: D4977-1 HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 Job: 20140538 PO: PO25511		
5 ea	Part: D4977-2 HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 Job: 20140539 PO: PO25511		
5 ea	Part: D4970-3 HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 Job: 20140540 PO: PO25511		
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE : <u>27/8</u></p> <p>CERTIFIED SIGNATURE: </p> <p>RECEIVER SIGNATURE: </p>			